

ABSTRACT

A method of vulcanization-molding a rubber material, in which lengths of vent-spews and protrusions in a rubber product can be shortened to an extent not damaging an appearance of the product without removing through  
5 trimming and without obstructing the discharge of enclosed air or the like and there is not caused a fear that vent-holes and the like are clogged with broken vent-spews and the like, is provided by heating a vulcanization mold and pushing the rubber material onto a shaping face of the mold through a pressure supplied to an interior of the mold, wherein a low-pressure fluid is supplied to the interior  
10 of the mold at an initial stage of the vulcanization molding and thereafter the pressure of the fluid is increased stepwise or stepless.